



Formulation

Chromate Free 1K Epoxy Etch Primer using HALOX CW-491

<u>GRIND</u>		<u>LBS./100 GALS.</u>	<u>GRAMS/LITER</u>
Beckopox EM 460	[1]	123.36	148.03
<i>Premix the following 4 ingredients and mix until uniform.</i>			
Mowital B 30 H	[2]	73.65	88.38
n-Butanol		73.65	88.38
Eastman PM	[3]	73.65	88.38
Xylene/ Xylol		147.30	176.76
Bayferrox 120M	[4]	44.19	53.03
HALOX CW-491		73.65	88.38
Microtalc MP 1538	[5]	73.65	88.38

High speed disperse to 6+ NS Hegman grind.

LETDOWN

Premix the following 3 ingredients and mix until uniform.

Xylene/ Xylol		25.04	30.05
Aerosil R 972	[6]	2.95	3.54
Additol XL 270	[1]	1.47	1.76
n-Butanol		53.58	64.30
Eastman PM	[3]	53.58	64.30
Xylene/ Xylol		71.44	85.73

Premix the following before adding.

Phosphoric Acid (85%)		7.36	8.83
n-Butanol		22.09	26.51

Mix until uniform.

TOTAL		920.61	1104.74
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FORMULA CONSTANTS

%Pigment/Wt.	21.12
%Pigment/Vol.	7.57
%Solids/Wt.	37.87
%Solids/Vol.	23.72
%PVC	31.90
VOC lbs./gal.	5.73
VOC g/l	686.25

FORMULA PROPERTIES

Density lbs./gal.	9.21
Density g/l	1105.00
KU Visc. @ R.T.	70-75

Package Stability is EQUAL to

Control Formula without Inhibitor.

SUPPLIER KEY

- [1] Vianova Resins, Inc.
- [2] Clariant
- [3] Eastman Chemical Co.
- [4] Bayer Corp.
- [5] Specialty Mineral, Inc.
- [6] Degussa Corp.

The information contained herein is correct to the best of our knowledge, but is intended only as a source of information. The recommendations or suggestions herein are made without guarantee of representation as to results, and we suggest that you evaluate the recommendations contained in this formulation in you own laboratory prior to use.

MOB30H/491

WN-122898

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